

Date: Monday, 4/10/2006 11:13:26 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : COVER PLATE ASSEMBLY, LH
 Job Number : 26604
 Estimate Number : 12301
 P.O. Number : N/A Part Number : D3467047
 This Issue : 4/10/2006 S.O. No. : N/A Drawing Number : D3467 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL / MED FAB Drawing Revision : A
 Previous Run : 26261 Material : N/A
 Written By : See Comment Below Due Date : 4/28/2006 Qty: 1 Um: Each
 Checked & Approved By : 06-04-10
 Comment : Est Rev: A New Issue 06-03-01 EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D34671 COVER PLATE LH



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3467-1	Shourd Plate	B26961

SB 06/04/27 (5)

2.0 D34677 SEAL STRIP



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3467-7	Doubler	B26711

SB 06/04/27 (5)

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3467

2-Spot Weld as per Dwg D3467 and Dart QSI 004

3-Identify as D3467-047

SB 06/04/27 (5)

4.0 QC5/W WELD INSPECTION



Comment: WELD INSPECTION

SB 06/04/27 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PS Date: 06/01/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/10/2006 11:13:26 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COVER PLATE ASSEMBLY, LH

Job Number: 26604

Part Number: D3467047

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: _____

Electro Chemically Polish weldment as per Dwg Dwg D3467

Ensure Certificate of Conformity is attached

Identify as D3467-047

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT

1-Inspect finish

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



120604-27 (5)
Doc 04/28
u 06-04-28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

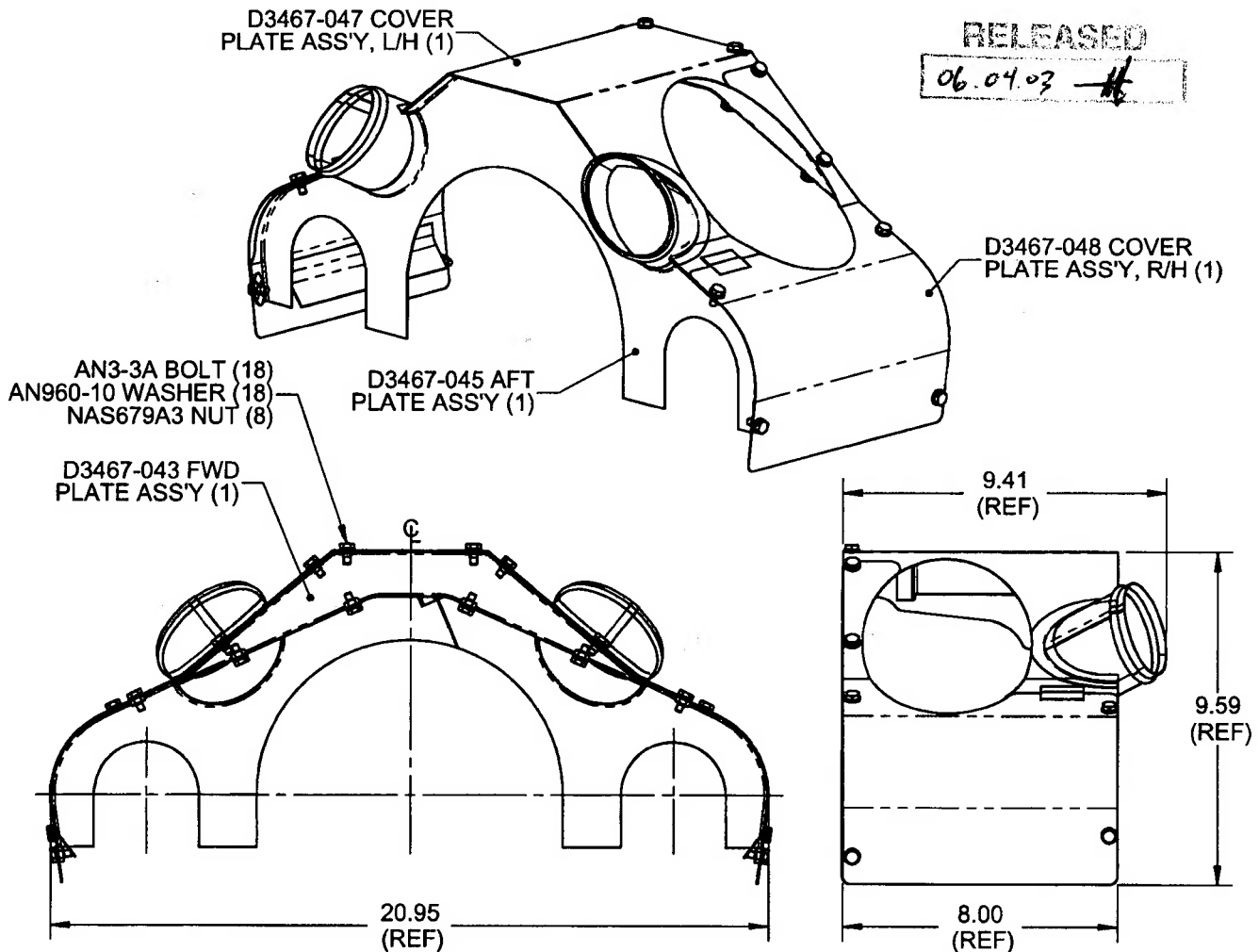
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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DATE 05.12.07		TITLE SHROUD ASSEMBLY	SCALE 1:5
A	05.12.07	NEW ISSUE	



D3467-041 SHROUD ASSEMBLY

NOTES:

- 1) IDENTIFY WITH DART P/N D3467-041 USING FINE POINT PERMANENT INK MARKER
- 2) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3467-041	SHROUD ASSEMBLY
1	D3467-043	FWD PLATE ASSEMBLY
1	D3467-045	AFT PLATE ASSEMBLY
1	D3467-047	COVER PLATE ASSEMBLY, L/H
1	D3467-048	COVER PLATE ASSEMBLY, R/H
18	AN3-3A	BOLT
18	AN960-10	WASHER
8	NAS679A3	NUT

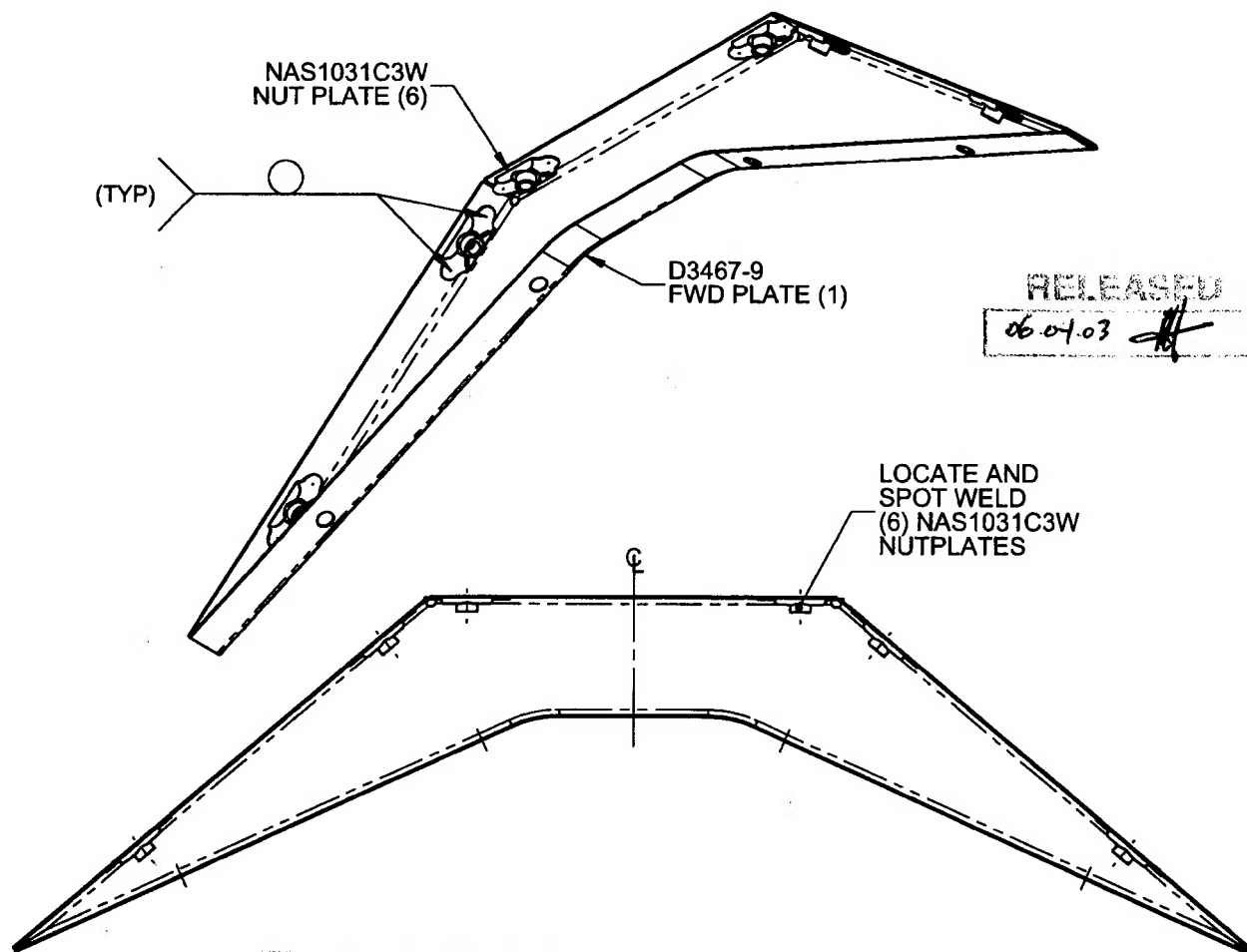
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DATE 05.12.07		TITLE SHROUD ASSEMBLY	SHEET 2 OF 15 SCALE 1:2



QTY -043	P/N	DESCRIPTION
X	D3467-043	FWD PLATE ASSEMBLY
1	D3467-9	FWD PLATE
6	NAS1031C3W	NUT PLATE

D3467-043 FWD PLATE ASSEMBLY

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) ASSEMBLY IS SYMETRICAL ABOUT CENTER LINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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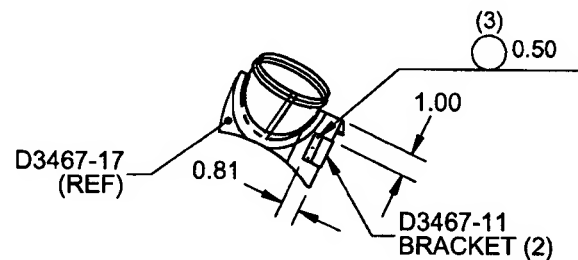
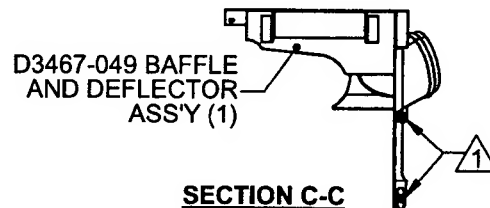
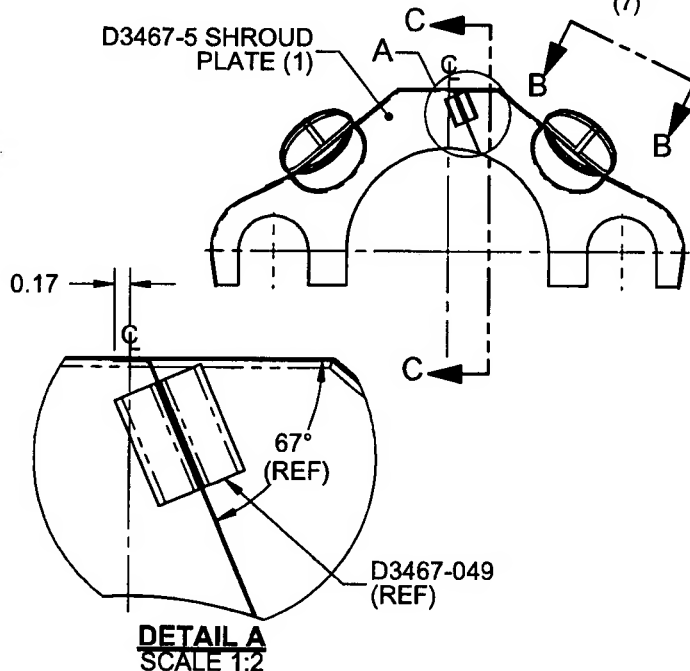
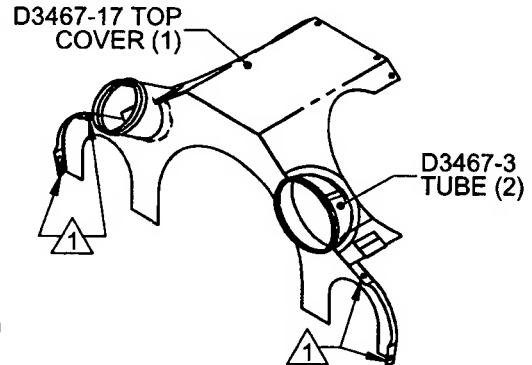
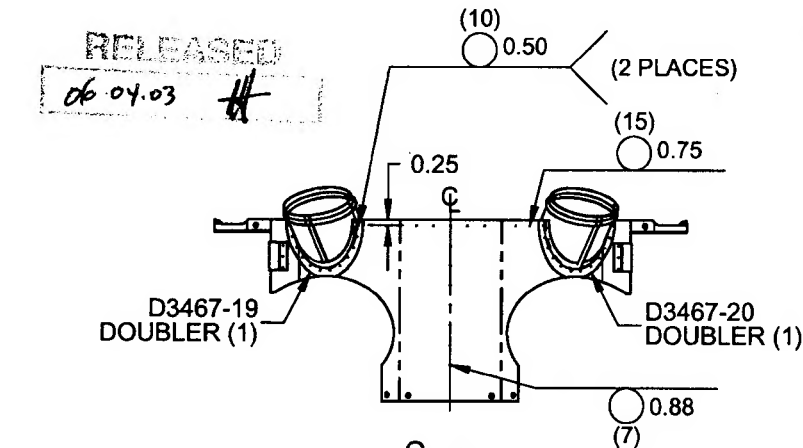
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DATE 05.12.07		TITLE SHROUD ASSEMBLY	SHEET 3 OF 15 SCALE 1:8

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06 04.03 *[Signature]*

VIEW B-B: WELDING D3467-11
D3467-047 NOT SHOWN FOR CLARITY
(2 PLACES)

D3467-045 AFT PLATE ASSEMBLY

NOTES:

- 1) LOCATE AND SPOT WELD NAS1031C3W NUTPLATE (4) TO D3467-5 PRIOR WELDING OTHER PARTS TO D3467-5
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -045	P/N	DESCRIPTION
X	D3467-045	AFT PLATE ASSEMBLY
1	D3467-049	BAFFLE AND DEFLECTOR ASSEMBLY
2	D3467-3	TUBE
1	D3467-5	SHROUD PLATE
2	D3467-11	BRACKET
1	D3467-17	TOP COVER
1	D3467-19	DOUBLER
1	D3467-20	DOUBLER
4	NAS1031C3W	NUT PLATE

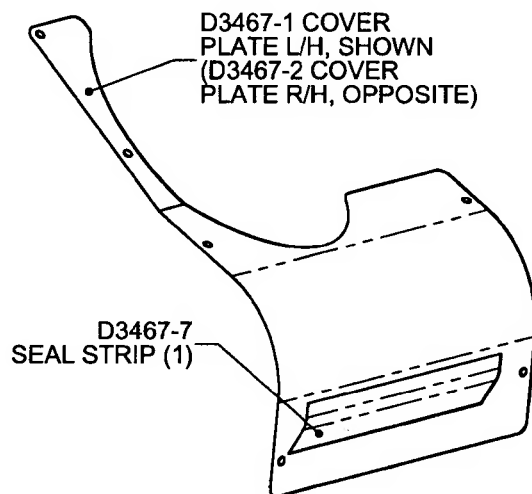
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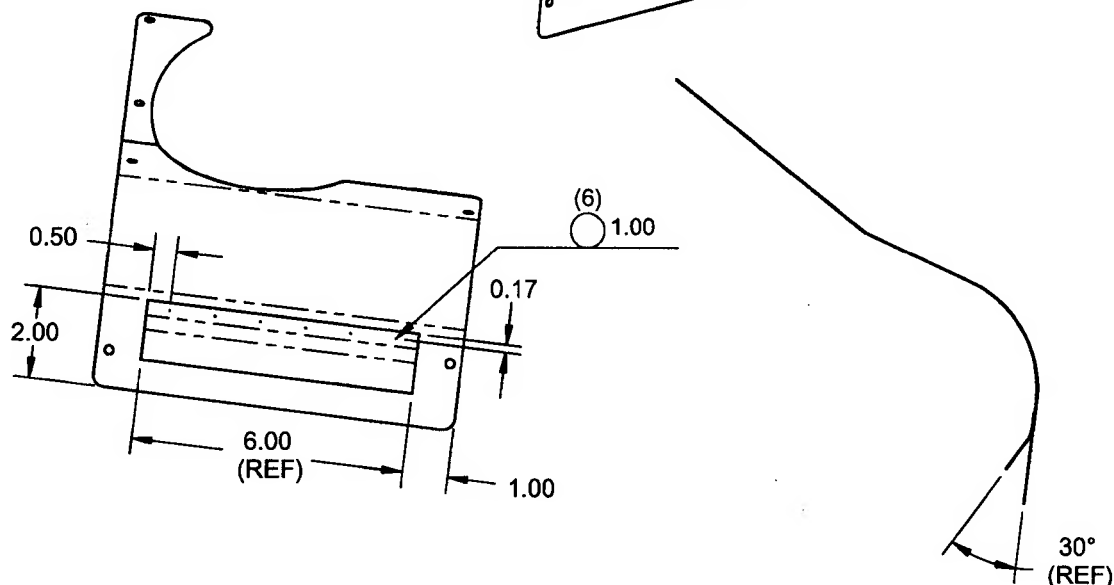
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DATE 05.12.07		TITLE SHROUD ASSEMBLY	SCALE 1:4



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D3467-047 COVER PLATE ASS'Y L/H, SHOWN
D3467-048 COVER PLATE ASS'Y R/H, OPPOSITE

NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

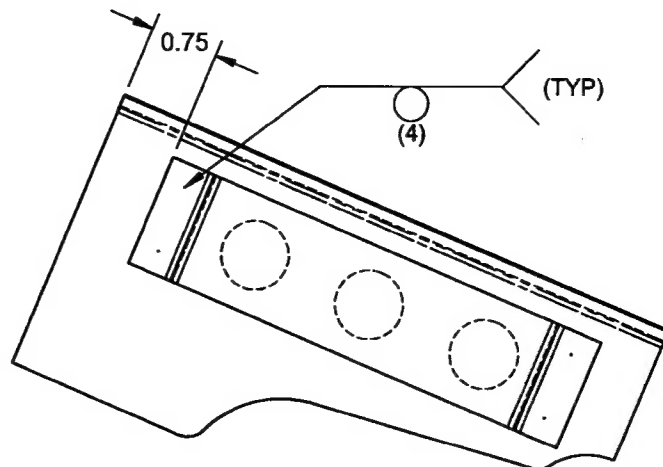
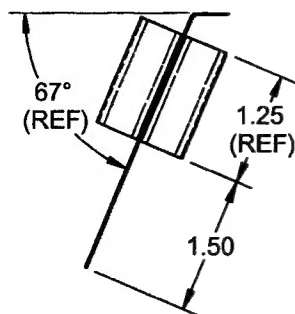
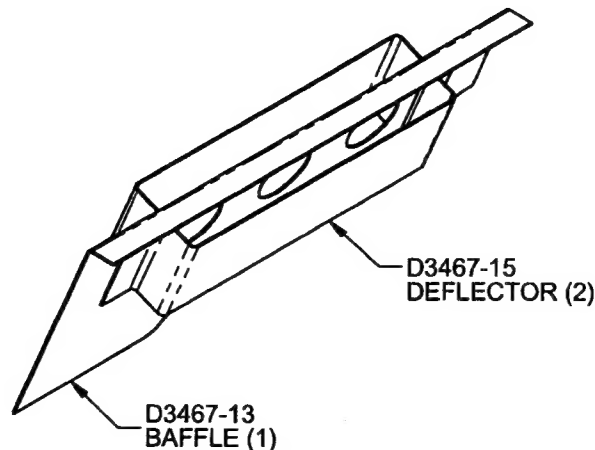
QTY -047	QTY -048	P/N	DESCRIPTION	SHOP COPY RETURN TO ENGINEERING CONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO 26604
X		D3467-047	COVER PLATE ASSEMBLY, L/H	
	X	D3467-048	COVER PLATE ASSEMBLY, R/H	
1		D3467-1	COVER PLATE, L/H	
	1	D3467-2	COVER PLATE, R/H	
1	1	D3467-7	SEAL STRIP	

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D3467-049 BAFFLE & DEFLECTOR ASSEMBLY

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NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

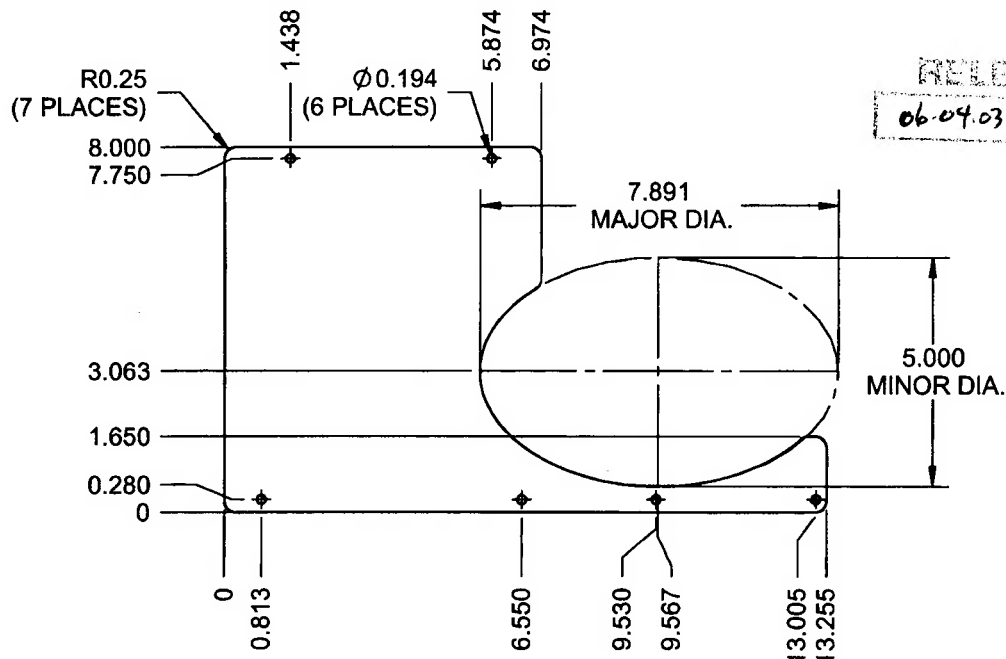
QTY -049	P/N	DESCRIPTION
	D3467-049	BAFFLE & DEFLECTOR ASSEMBLY
1	D3467-13	BAFFLE
2	D3467-15	DEFLECTOR

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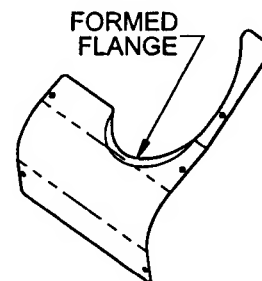
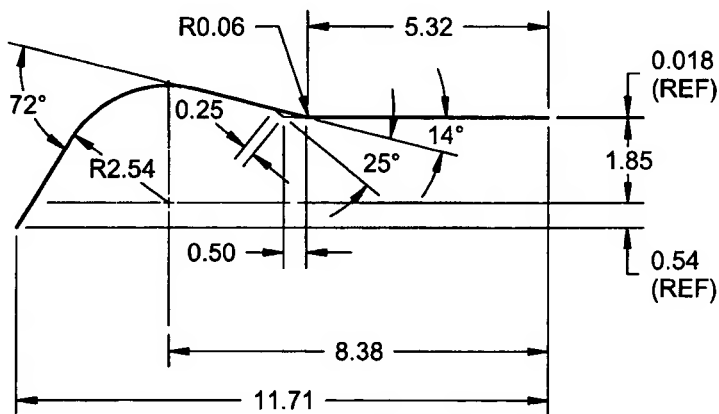
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DATE 05.12.07		TITLE SHROUD ASSEMBLY	SCALE 1:4



D3467-1F COVER PLATE FLAT PATTERN



D3467-1 L/H COVER PLATE D3467-2 R/H COVER PLATE (OPPOSITE)

D3467-1 L/H COVER PLATE ISOMETRIC VIEW D3467-2 R/H COVER PLATE (OPPOSITE) SCALE 1:8

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

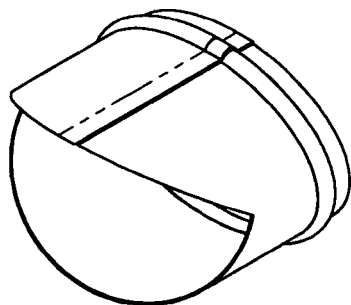
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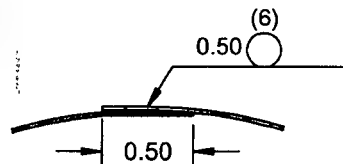
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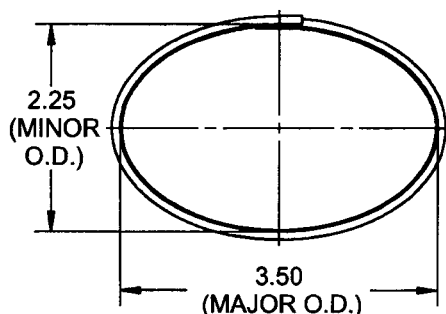
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DATE 05.12.07	TITLE SHROUD ASSEMBLY		SCALE 1:2



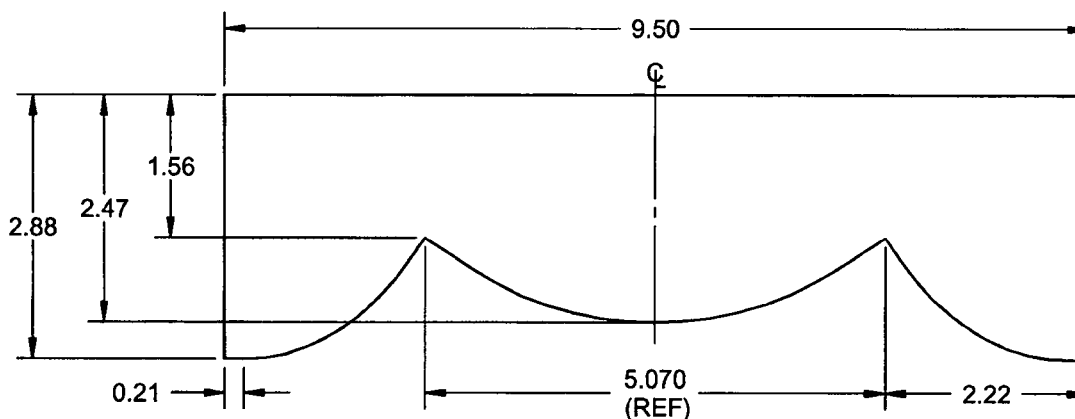
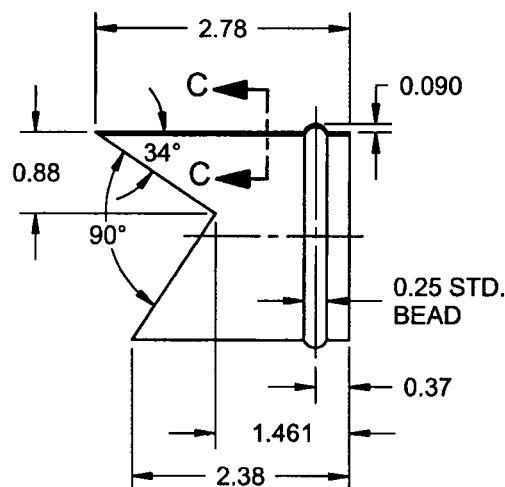
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SECTION C-C
SCALE 1:1



D3467-3 TUBE DETAIL



D3467-3F TUBE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 3) SPOT WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

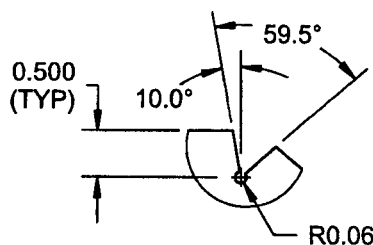
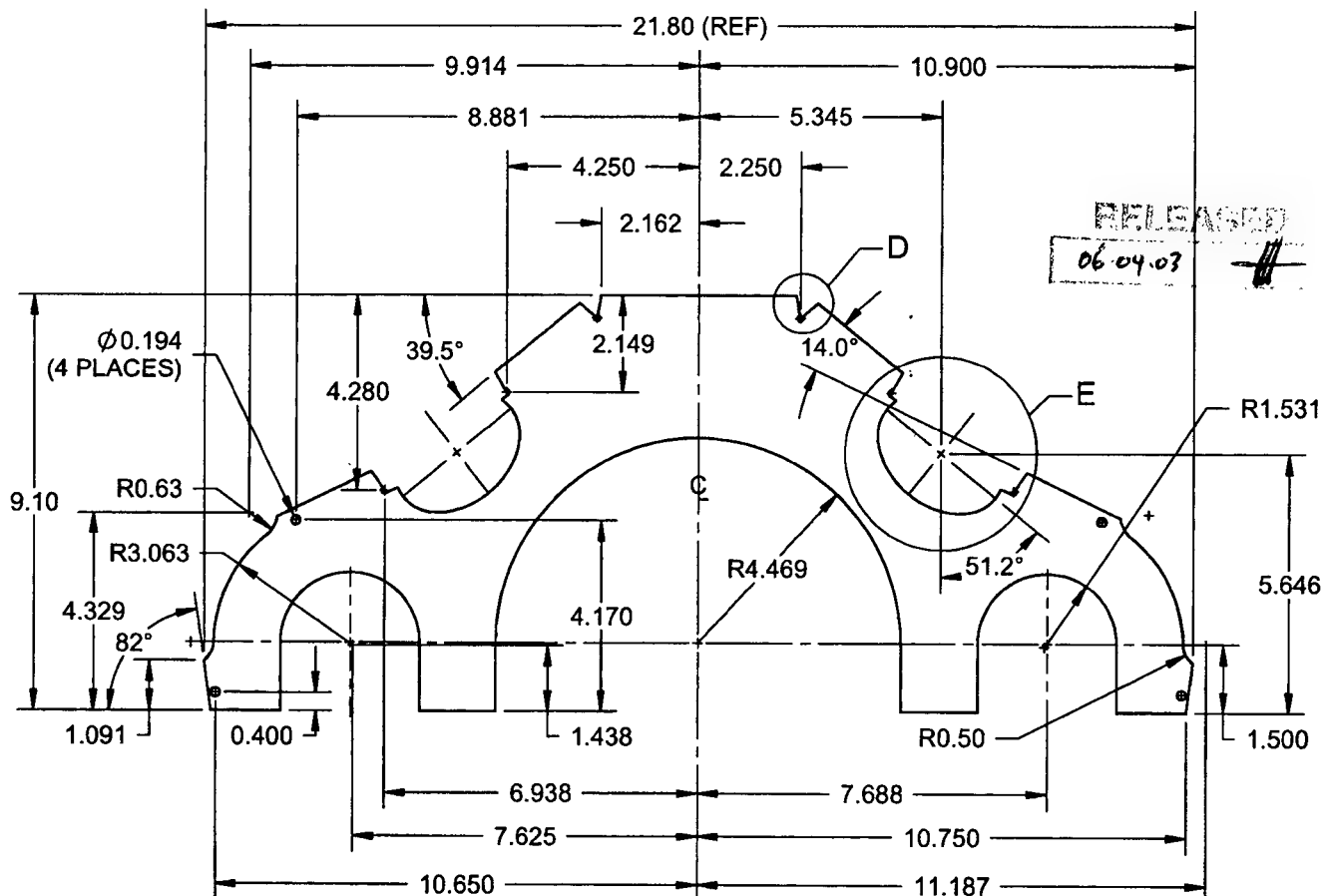
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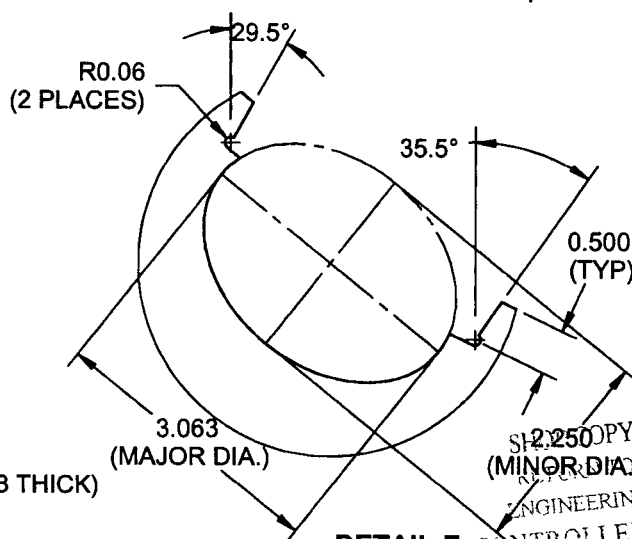
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DATE 05.12.07		TITLE SHROUD ASSEMBLY	SHEET 8 OF 15 SCALE 1:8



DETAIL D
SCALE 1:2



DETAIL E
SCALE 1:2

D3467-5F AFT PLATE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

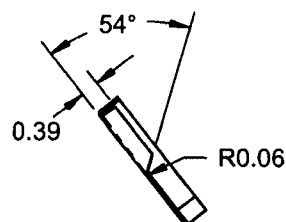
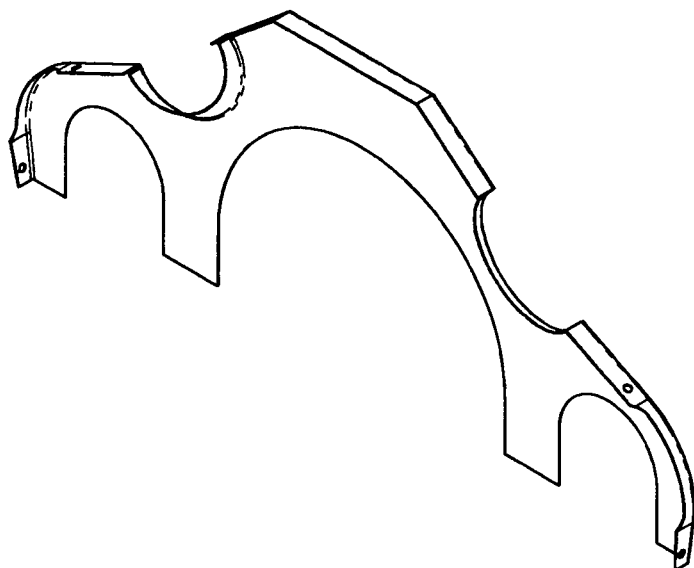
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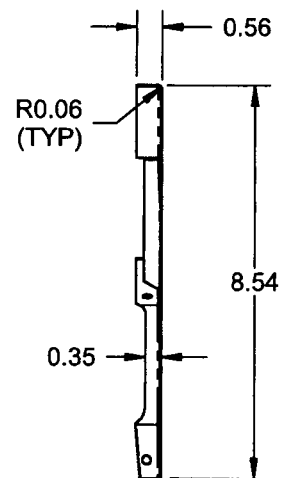
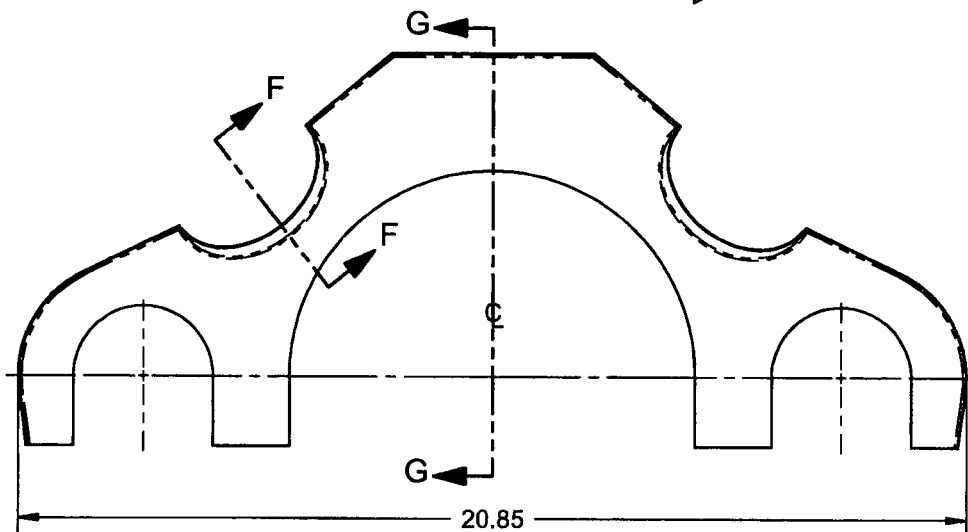
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DATE 05.12.07	TITLE SHROUD ASSEMBLY		SCALE 1:4



SECTION F-F



SECTION G-G

D3467-5 AFT PLATE BENDING DETAIL

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

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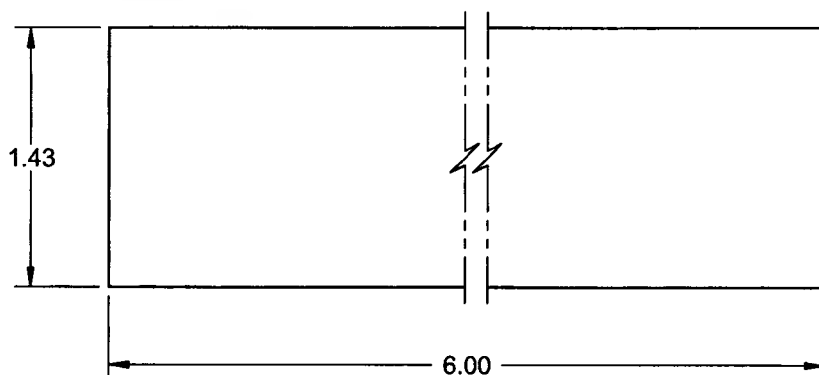
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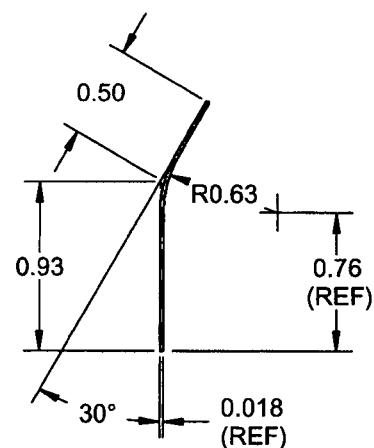


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DATE 05.12.07		TITLE SHROUD ASSEMBLY	SCALE 1:1

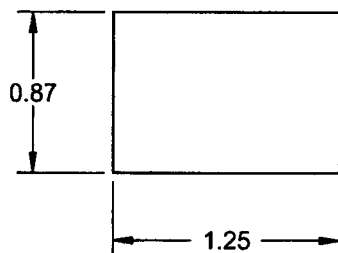
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06 04 03 *[Signature]*



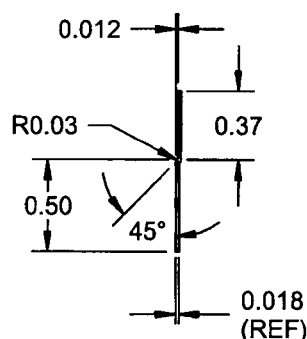
**D3467-7F SEAL STRIP
FLAT PATTERN**



**D3467-7 SEAL STRIP
BENDING DETAIL**



**D3467-11F BRACKET
FLAT PATTERN**



**D3467-11 BRACKET
JOGGLE DETAIL**

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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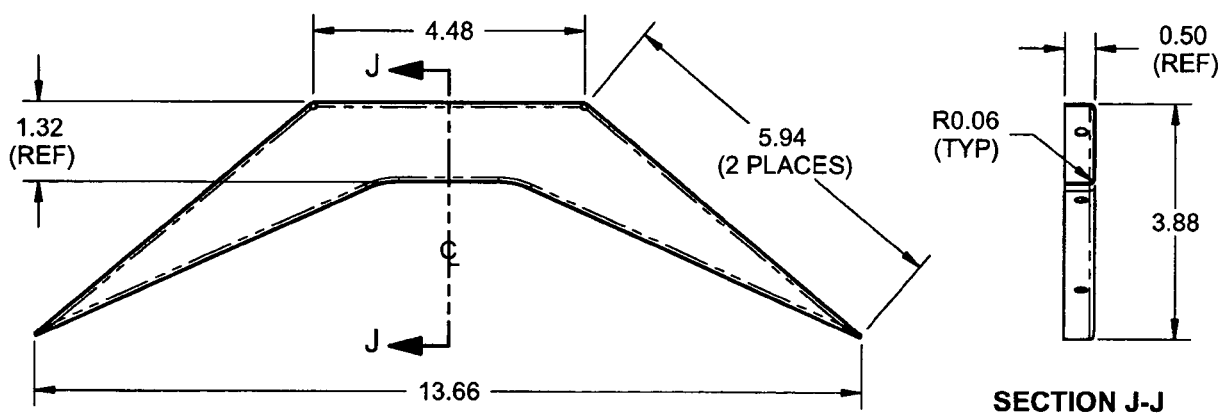
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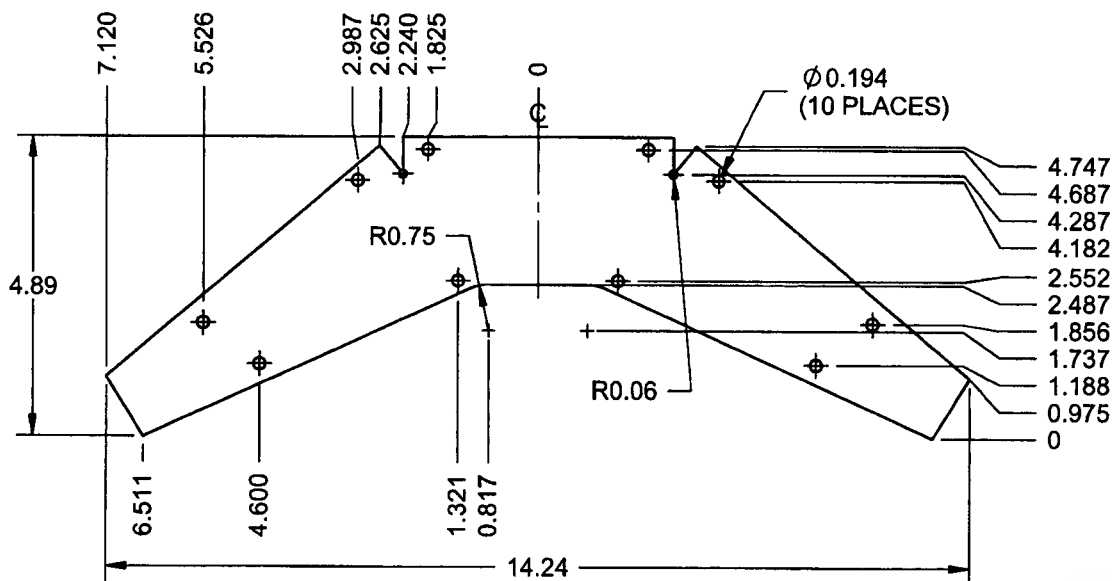
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DATE 05.12.07		TITLE SHROUD ASSEMBLY	SCALE 1:3



D3467-9 FWD PLATE BENDING DETAIL



D3467-9F FWD PLATE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTER LINE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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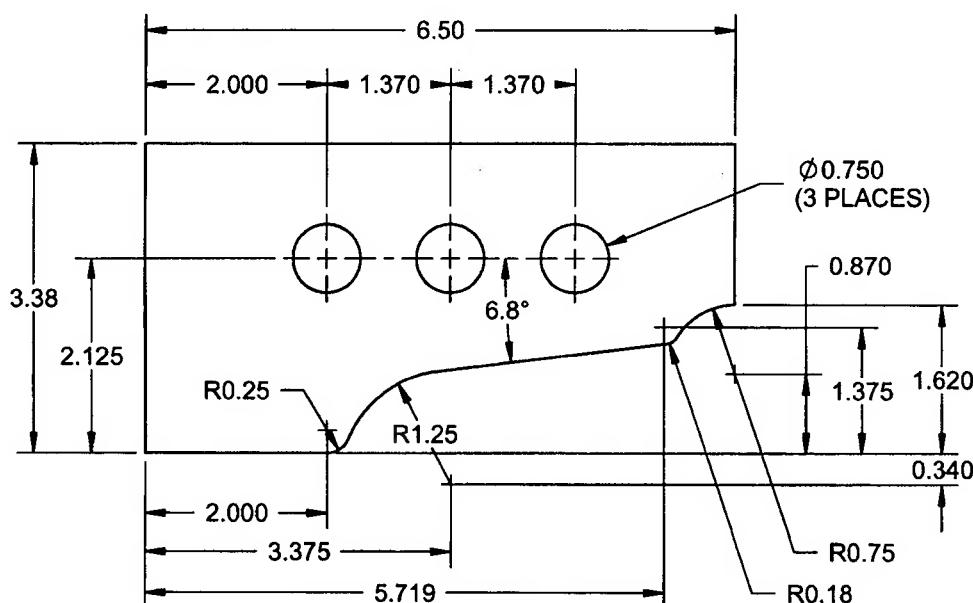
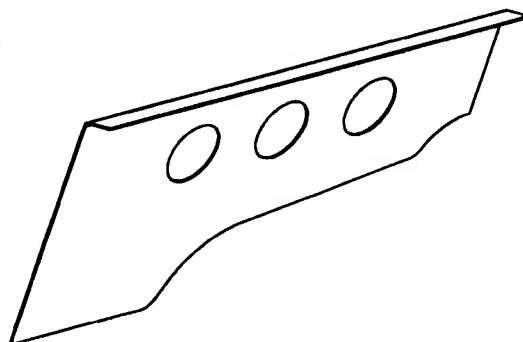
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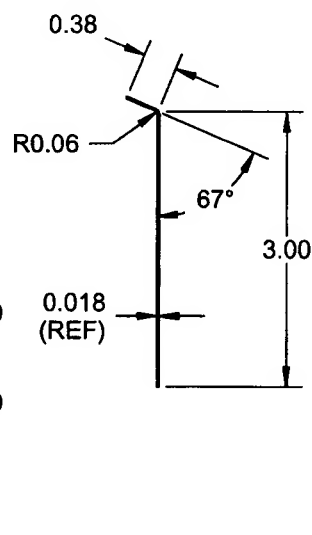


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DATE 05.12.07		TITLE SHROUD ASSEMBLY	SHEET 12 OF 15 SCALE 1:2

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06-04-03 H



**D3467-13F BAFFLE
FLAT PATTERN**



**D3467-13 BAFFLE
BEND DETAIL**

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

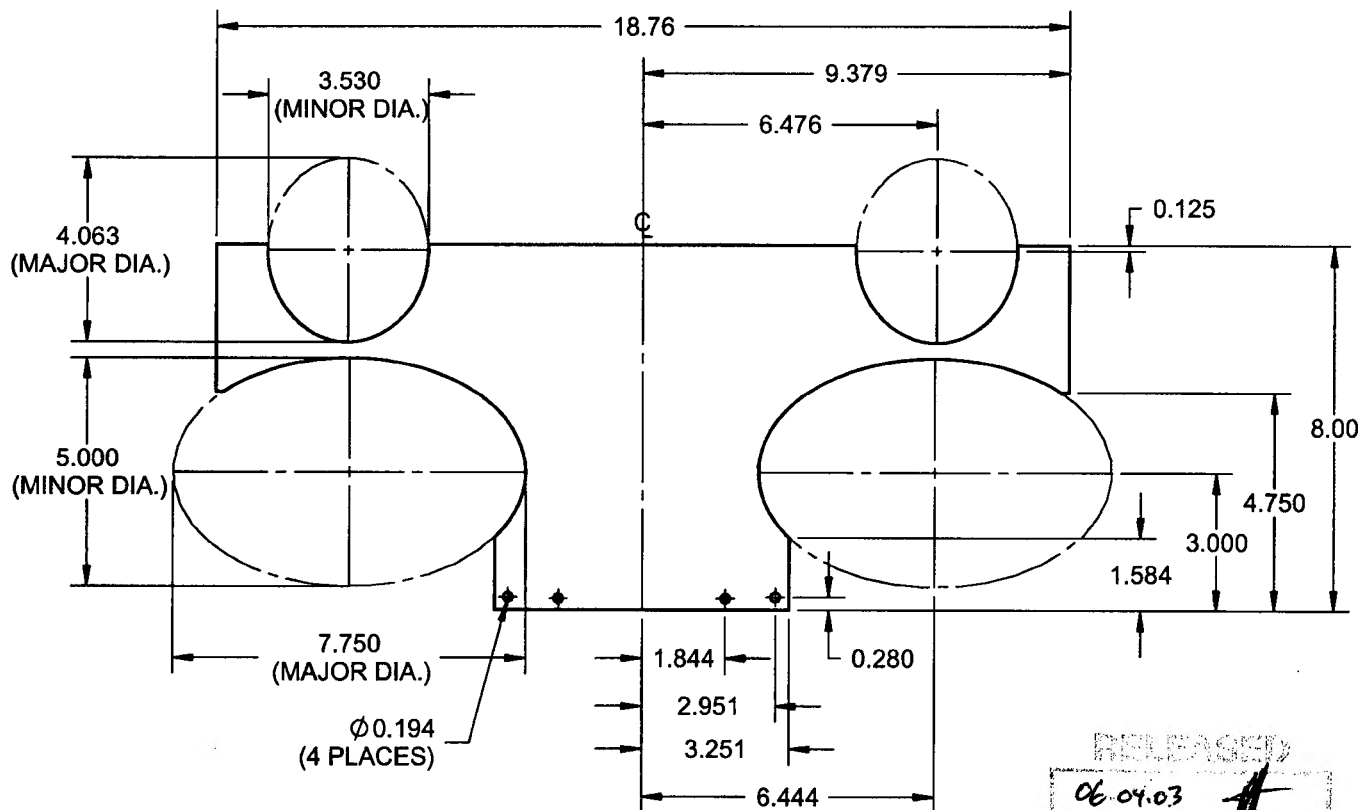
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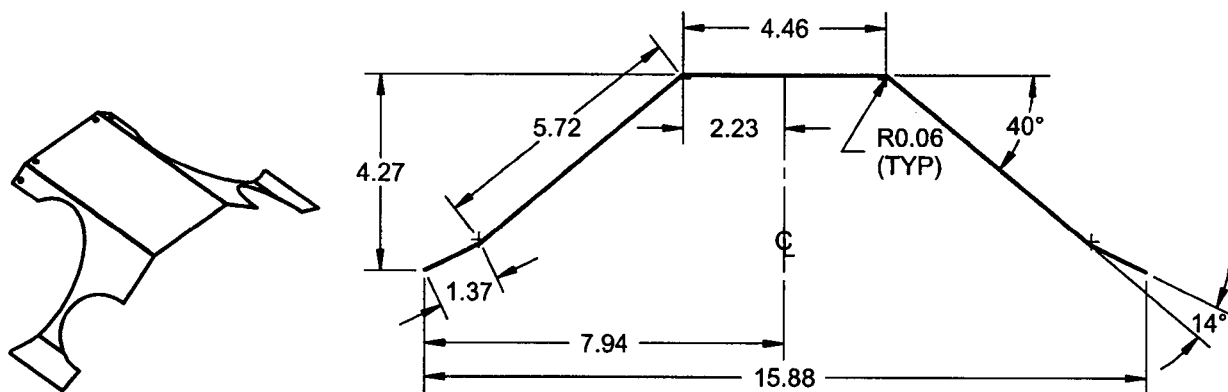
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DATE 05.12.07		TITLE SHROUD ASSEMBLY	SHEET 14 OF 15 SCALE 1:4



D3467-17F TOP COVER FLAT PATTERN



D3467-17 TOP COVER BENDING DETAIL

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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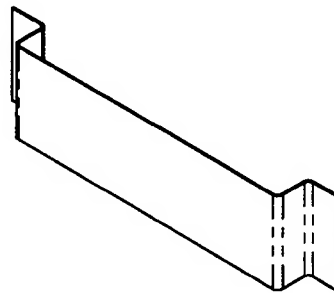
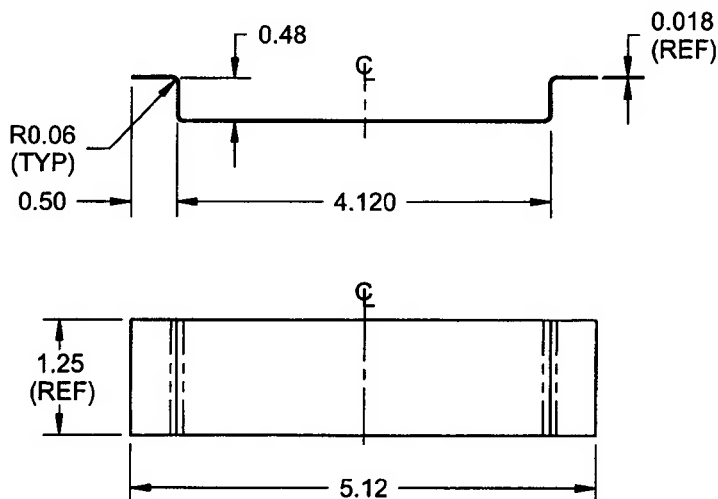
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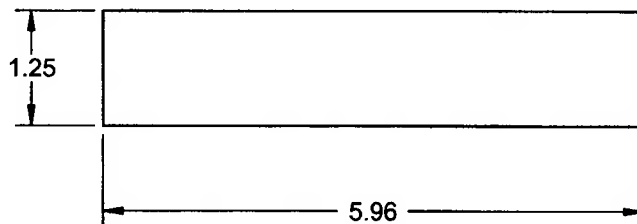


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DATE 05.12.07		TITLE SHROUD ASSEMBLY	SCALE 1:2

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D3467-15 DEFLECTOR BENDING DETAIL



D3467-15F DEFLECTOR FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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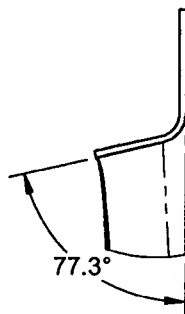
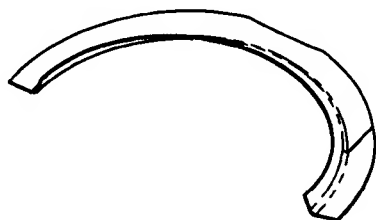
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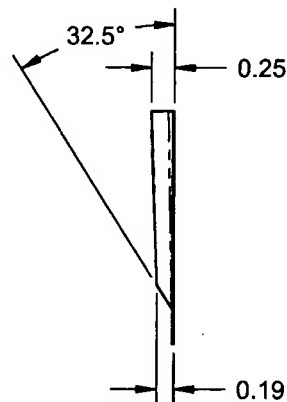
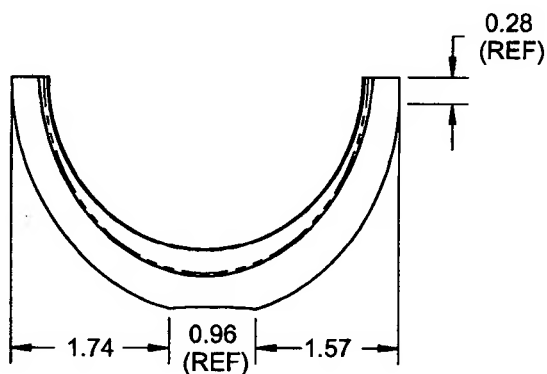


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DATE 05.12.07		TITLE SHROUD ASSEMBLY	SCALE 1:2

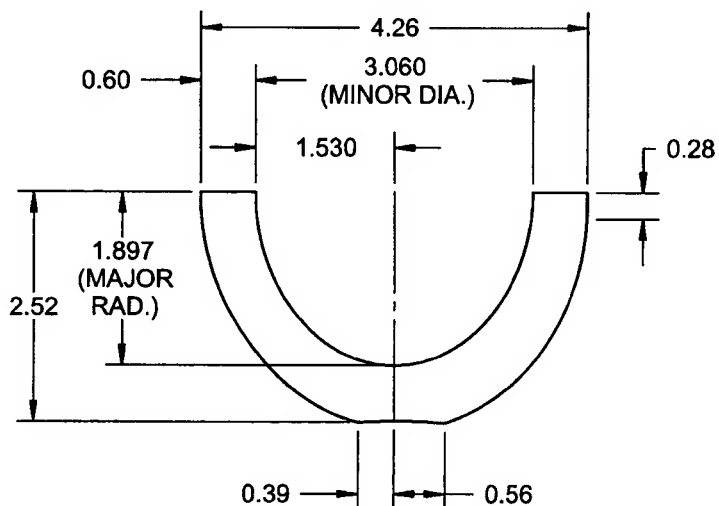
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DETAIL J
SCALE 1:2



D3467-19 DOUBLER, L/H SHOWN
D3467-20 DOUBLER, R/H OPPOSITE



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D3467-19F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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